

WIRE FEED UNIT

DX7i

SAFETY INSTRUCTIONS FOR USE AND MAINTENANCE

MACHINE N° W000383785 - W000383786



EDITION : EN
REVISION : B
DATE : 03-2019

Instruction manual

REF : **8695 5234**

Original instructions

LINCOLN[®]
ELECTRIC

Thank you very much for the trust you have shown by choosing this piece of equipment. It will give you trouble-free service if it is used and maintained as recommended.

Its design, component specifications and manufacturing are in accordance with applicable European directives.

Please refer to the CE declaration enclosed to identify the directives applicable to it.

The manufacturer shall not be liable for any combination of parts not recommended by it.

For your safety, please follow the non-limitative list of recommendations and obligations, a large part of which are included in the Labour Code.

Please inform your supplier if you find any error in this instruction manual.

CONTENTS

- A - IDENTIFICATION1**
- B - SAFETY INSTRUCTIONS.....2**
 - 1 - AIRBORNE NOISE2
 - 2 - PARTICULAR SAFETY INSTRUCTIONS2
- C - DESCRIPTION4**
 - 1 - FONCTION OF DX7i4
 - 2 - VERSIONS.....4
 - 3 - DX7i4
 - 4 - DESCRIPTION.....5
 - 5 - SPECIFICATIONS6
- D - ASSEMBLY AND INSTALLATION.....7**
 - 1 - HEAD ORIENTATION.....7
- E - OPERATING MANUAL8**
 - 1 - STARTING UP8
 - 2 - ELECTRICAL CONNECTIONS8
- F - MAINTENANCE.....9**
 - 1 - SPARE PARTS9
- PERSONAL NOTES12**

INFORMATION

DISPLAYS AND PRESSURE GAUGES

Measurement instruments or displays of voltage, intensity, speed, accuracy etc. are to be considered as indicators, whether they are analogue or digital.

For operating instructions, adjustments, troubleshooting and spare parts, please refer to the special instructions for safe use and maintenance.

REVISIONS

REVISION B

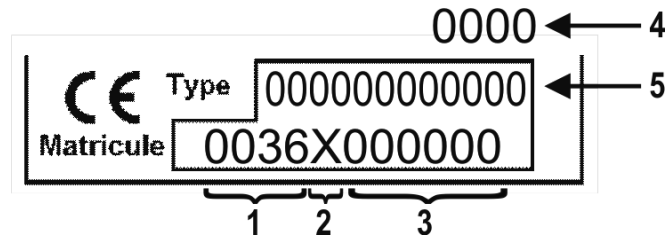
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DESIGNATION	PAGE
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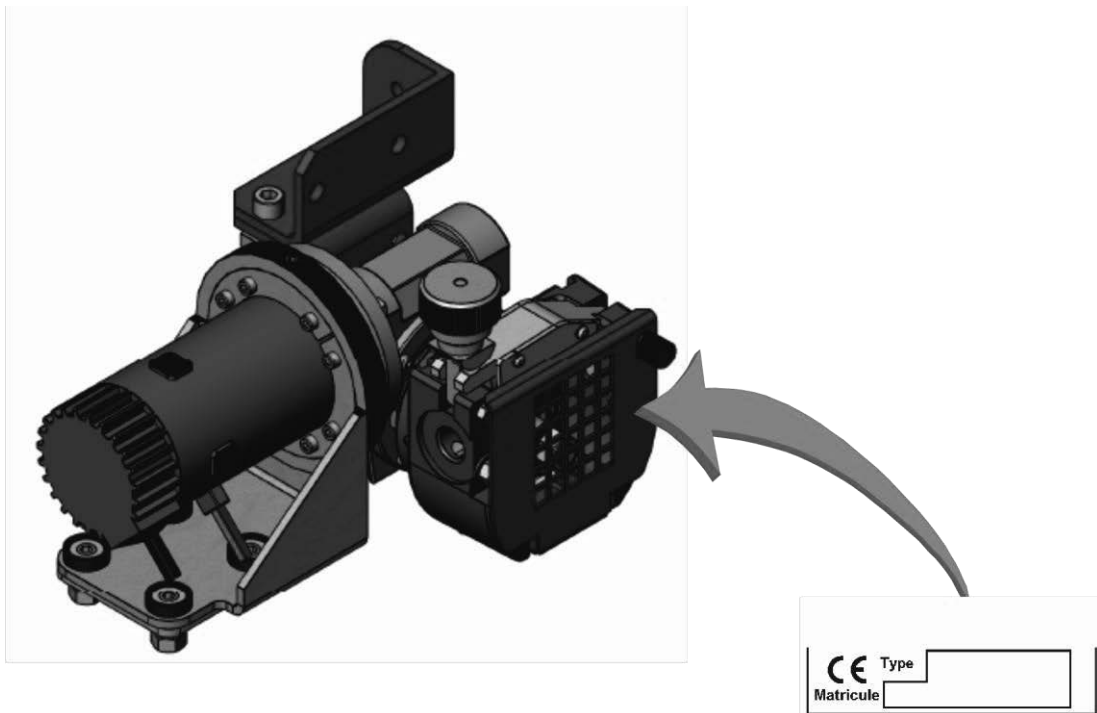
A - IDENTIFICATION

The information below should be provided in all correspondence.

Please note the serial number of your equipment in the box below.

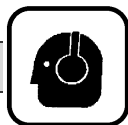


1	Manufacturing plant code	4	Year of manufacture
2	Year of manufacture code	5	Type of product
3	Product serial number		



B - SAFETY INSTRUCTIONS

For general safety instructions, please refer to the specific manual supplied with the equipment.



1 - AIRBORNE NOISE

Refer to the special instructions "8695 7051" supplied with the equipment.

2 - PARTICULAR SAFETY INSTRUCTIONS



Make sure that the guard covers of the electrical and mechanical parts are in place before starting up the equipment.



Make sure that the power and control conductors of the equipment are in good condition.



Clean the working area from time to time.



The use of Personal Protective Equipment (PPE) is **mandatory**.



Machine maintenance must be carried out **with all the energy supplies switched off**.
The disconnection and padlocking of all energy sources is **mandatory**.



Because the motor, reducing gear and plate all have the same potential (welding +), the metal parts must not touch the feed assembly.

C - DESCRIPTION

1 - FONCTION OF DX7i

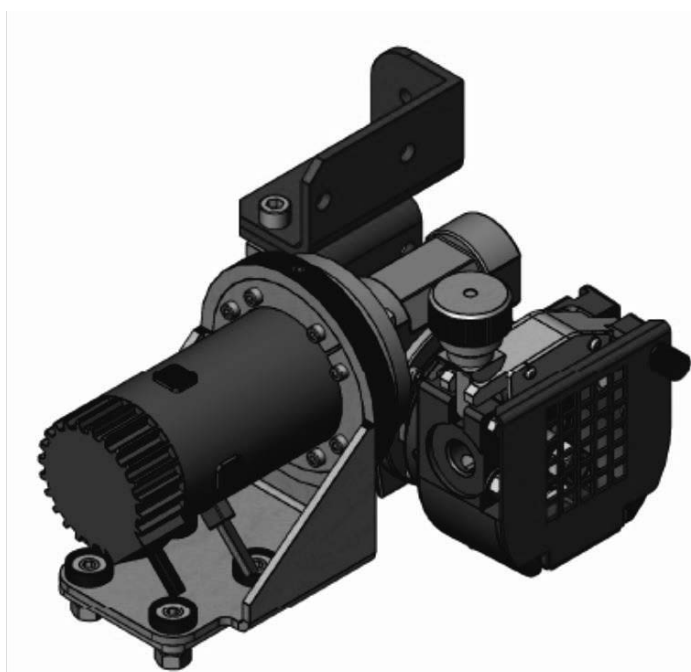
The **DX7i** plate gear motor unit feeds electrode wire for automatic flux welding equipment

2 - VERSIONS

<u>Speed max</u>	<u>DX7i</u>	<u>Single-wire</u>	<u>Twin-wire</u>
8 m/mn	W000383785	2,4 to 5,0 mm	2,0 to 2,4 mm
28 m/mn	W000383786	1,6 to 2,0 mm	1,2 to 1,6 mm

3 - DX7i

VERSION DX7i



4 - DESCRIPTION

Grease-lubricated gear motor **M12** is made up of a wheel and a worm.

The gear motor unit assembly has a fixing plate **M22** with four insulated screws to prevent arcing with the welding current.

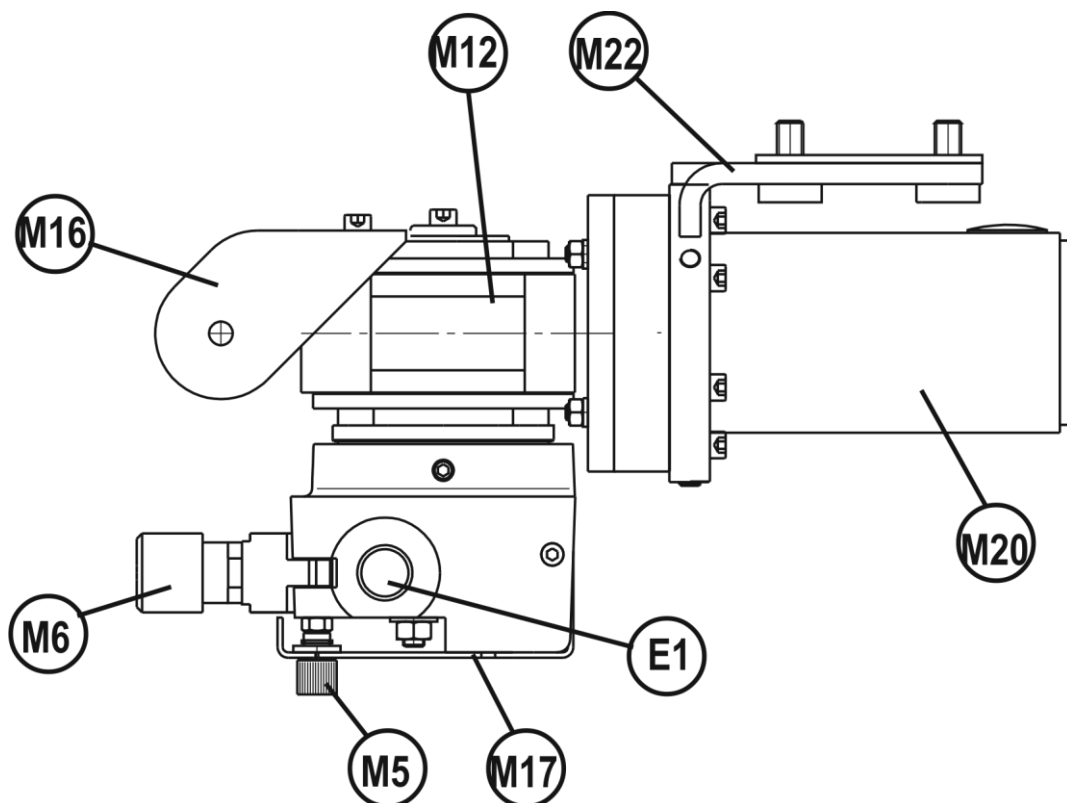
The assembly also has two flange systems to orient the wire output in two planes in relation to the fastening for optimised locating on the machines.

The plate has a shaft for two rollers that feed the electrode wire; the shaft may have three rollers for two-wire applications.

The lock roller can be locked with the help of knob **M6**. Inlet **E1** and the outlet from the plate are symmetrical, with a \varnothing of 18 mm. The fixing of the wire feed (A.S) or the torch (MIG/MAG) is achieved by a tangent buffer.

Cover **M17** guards the operator and can be opened with button **M5**.

Support tab **M16** is provided to fix the powder container in the submerged arc version.



5 - SPECIFICATIONS

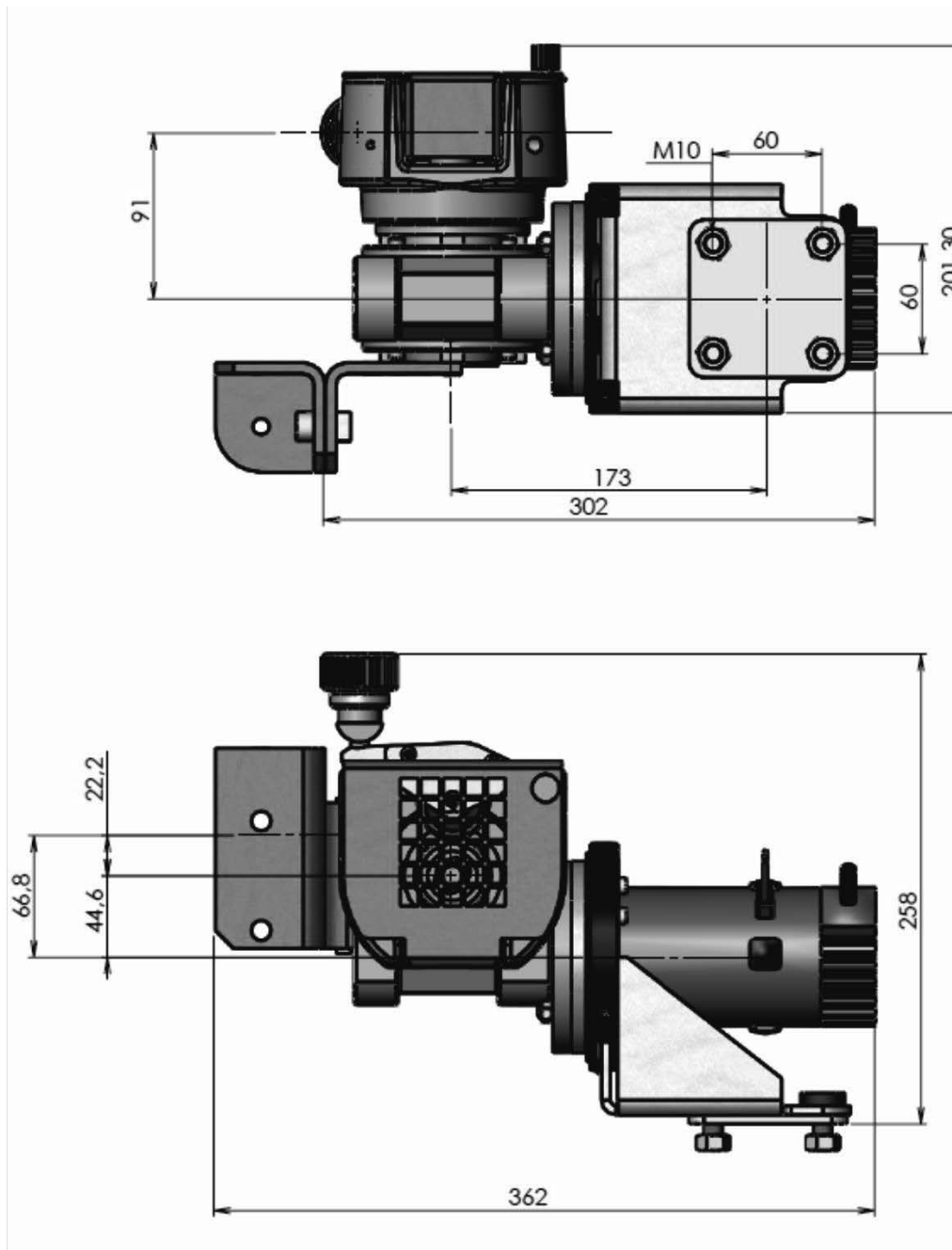
VERSION **DX7i**

- Power supply voltage 75 VDC
- I average current consumption under charge 5,2 Amperes
- Max. current consumption admissible 5.5 Amperes

The motor must be powered by a DVR600 speed unit

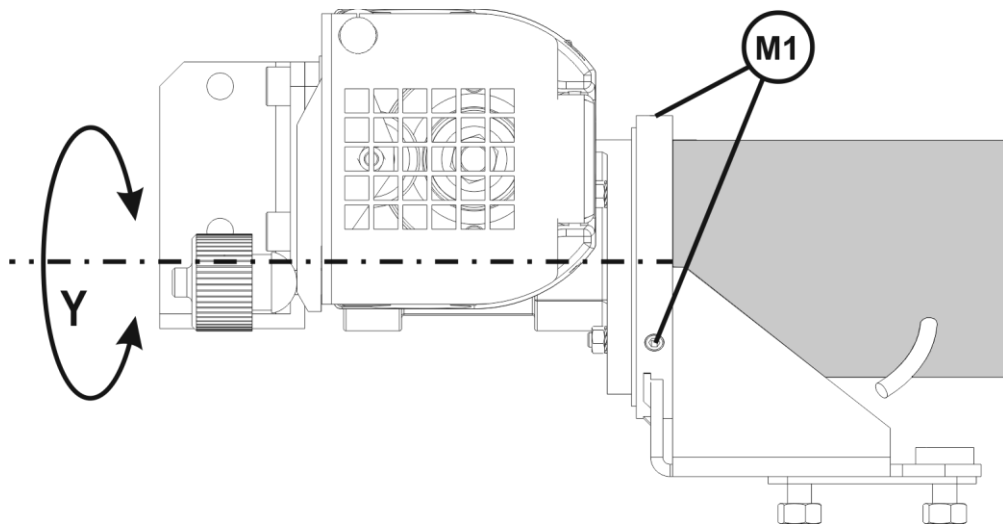
The feed speed range with a **DVR600** unit is from 0,15 à 8 m/mm with the **W000383785** model and 0,5 à 28 m/mm with the **W000383786** model.

The wire feed rollers are not part of unit **DX7i**

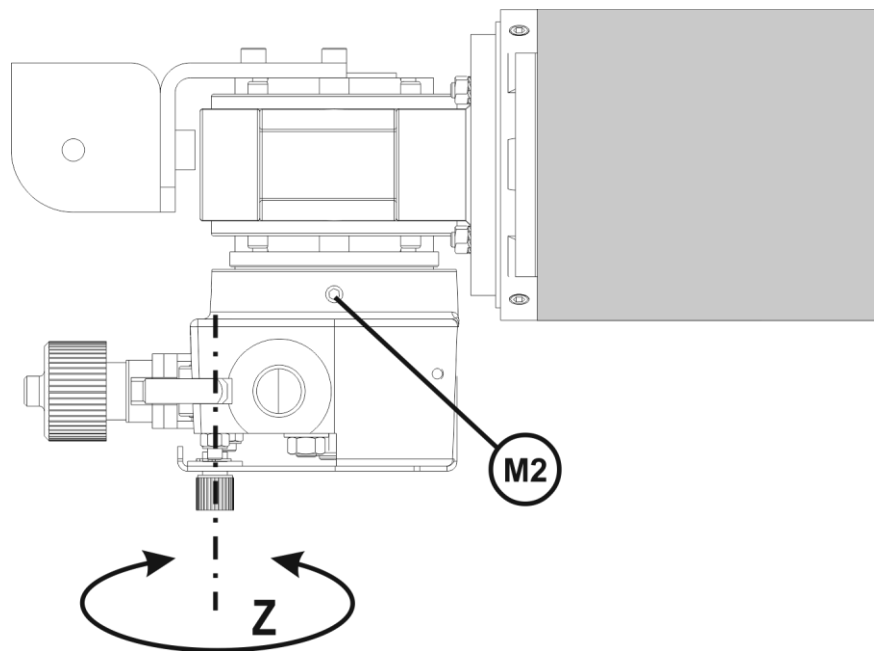


D - ASSEMBLY AND INSTALLATION

1 - HEAD ORIENTATION



The assembly can be turned along Y by unfastening the eight screws (**M1**)



The head can be turned along Z by unfastening the three screws (**M2**)

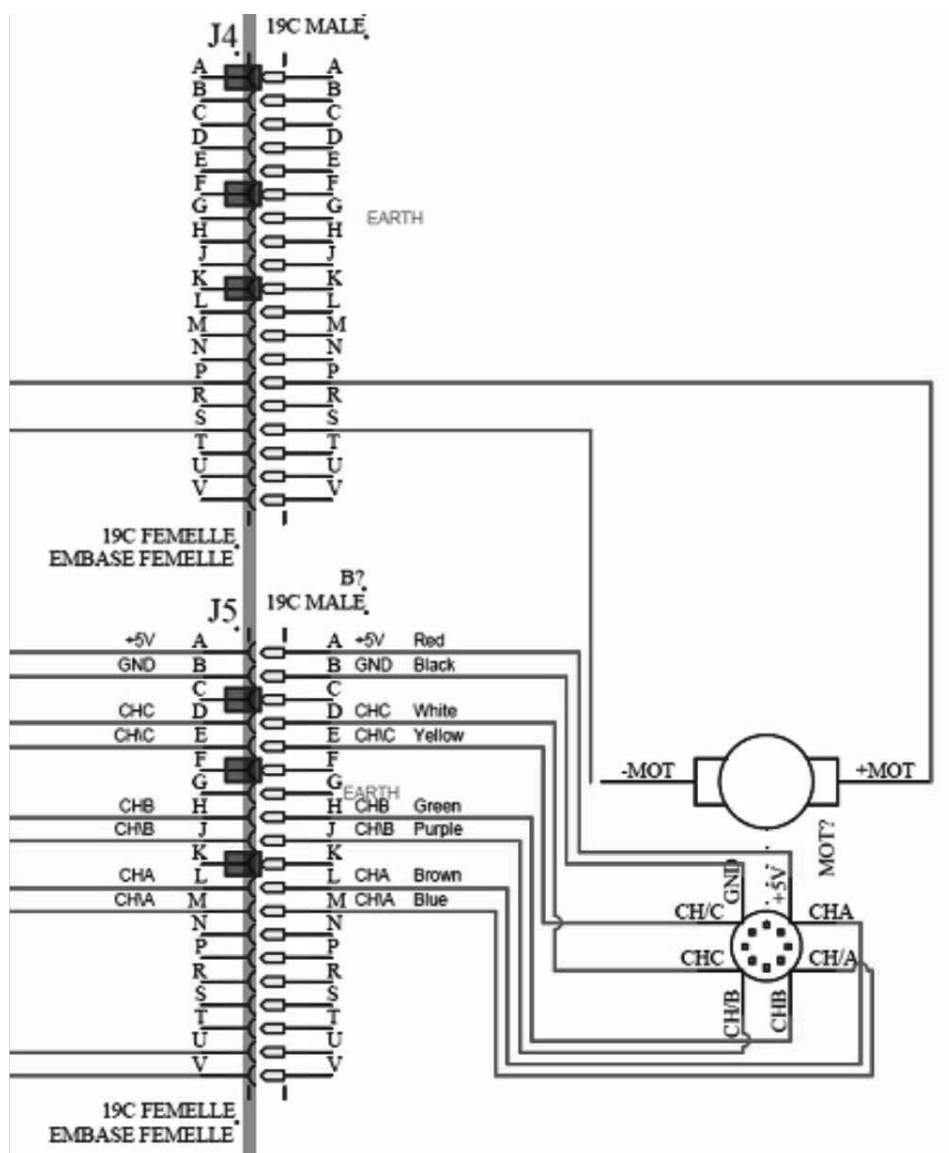
E - OPERATING MANUAL

1 - STARTING UP

Fix the gear motor assembly on the machine with four **M10** screws with a centre distance of 60mm (do not forget the insulating plate).

- Open the guard cover.
- Assemble the wire guide on the plate entry side and the torch (MIG- MAG) or wire feed (A.S) on the plate exit side.
- Fit the rollers onto the shaft and lock with the nut and washer.
- Feed the wire in the plate and fasten it with the lock roller plate using the knob.
- Close the guard cover.

2 - ELECTRICAL CONNECTIONS



F - MAINTENANCE

1 - SPARE PARTS

How to order

The photos or sketches identify nearly every part in a machine or an installation

The descriptive tables include 3 kinds of items:

- those normally held in stock: ✓
- articles not held in stock: ✗
- those available on request: no marks

(For these, we recommend that you send us a copy of the page with the list of parts duly completed. Please specify in the Order column the number of parts desired and indicate the type and the serial number of your equipment.)

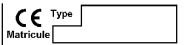
For items noted on the photos or sketches but not in the tables, send a copy of the page concerned, highlighting the particular mark.

For example:

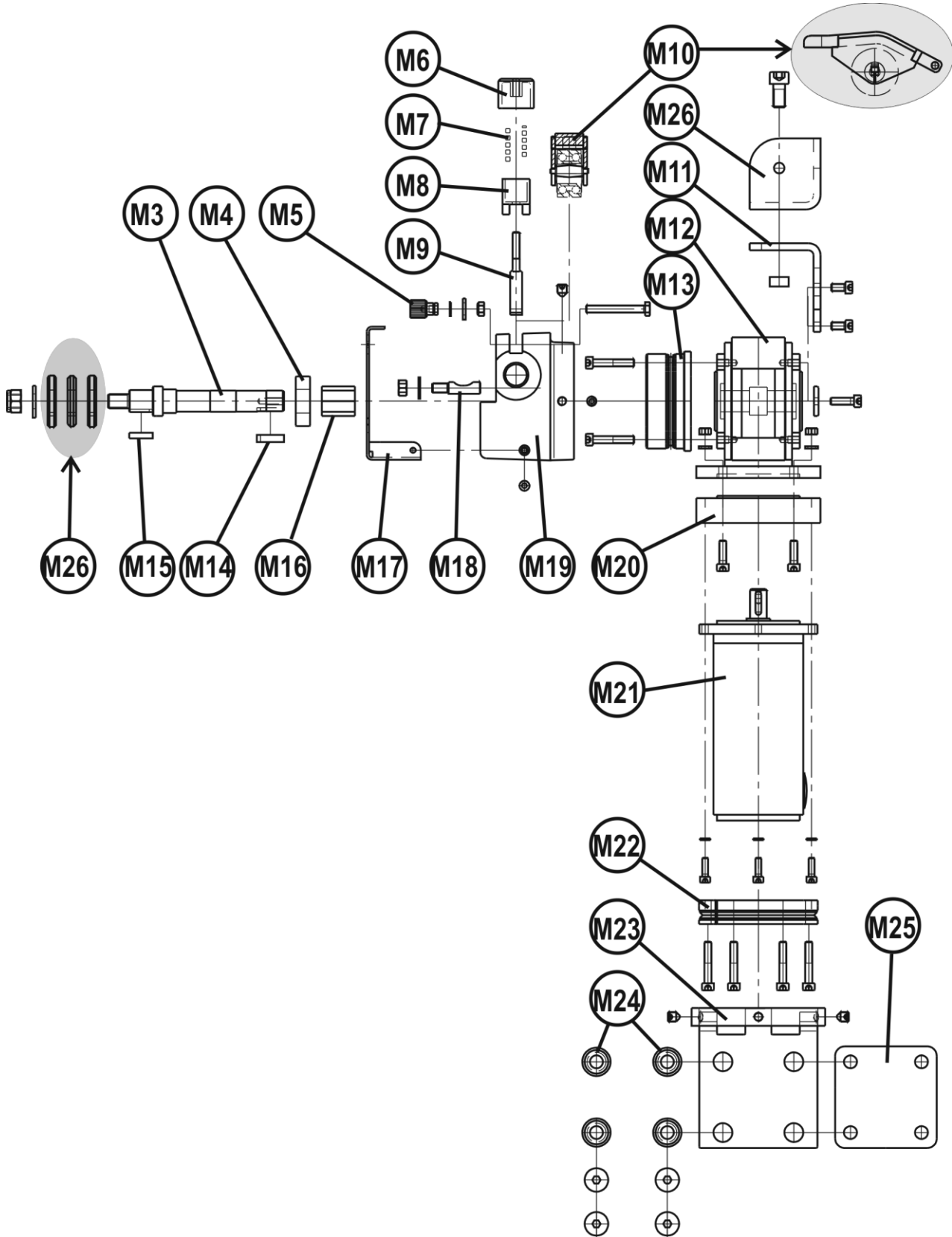
Item	Ref.	Stock	Order	Designation
1	W000XXXXXX	✓		Machine interface board
2	W000XXXXXX	✗		Flowmeter
3	9357 XXXX			Silk-screen printed front panel

✓	normally in stock
✗	not in stock
	on request

- For parts order, give the quantity required and put the number of your machine in the box below.

	TYPE:
	Number:

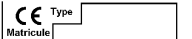
VERSION DX7i



✓	normally in stock
X	not in stock
	on request

Item	Ref.	Stock	Order	Designation
3	9109 6166			Feed plate shaft
4	.620 0429			20/40/12 6004 2RS bearing
5	9109 6146			Knob
6	9109 6149			Adjusting ring
7	.620 0371			Pressure spring
8	9109 6148			Adjusting end piece
9	9109 6147			Adjusting rod
10	W000269309	✓		Plate with pressure roller
11	9109 6296			Flux container support
26	9109 6297			Flux container support
12				Reducing gear
	W000383785	✓		VF44 P71 B14 R1/35 for 8 m/mn version
	W000383786	✓		VF44 P71 B14 R1/10 for 28 m/mn version
13	9109 6153			Plate hub
14	.620 1649			6/6/23 key
15	9109 4326			3/16 key
16	9109 6167			Spacer ring
17	9109 6154			Cover
18	9109 6156			Tangent buffer
19	9109 6152			DX7 plate
20	9109 6157			Motor spacer flange
21	W000383942	✓		GMP DX7i motor
22	9109 6159			Rotation flange
23	9109 6985			Turning support
24	9109 4327			Insulation for M10 screw
25	9109 4324			Fixing support insulation
<i>NOT INCLUDED IN THE UNIT</i>				
	W000237608	✓		Set of 2 rollers for one Ø 1,6 à Ø 2,4
	W000237609	✓		Set of 2 rollers for one Ø 3,2 à Ø 5
	9109 6175			Set of 2 rollers for one Ø 1,6 à Ø 2,4
	9109 6176			Set of 2 rollers for one Ø 3,2 à Ø 5
	W000234765	✓		Set of 3 rollers for two 1,2 / 2,4 mm

➤ For parts order, give the quantity required and put the number of your machine in the box below.

	TYPE:
	Number:

